



# Work Order ID 66931


Thursday, March 03, 2011 8:02:17 AM

Page 1

Item ID:	D3492-043	Accept		Setup	Start	
Revision ID:						
Item Name:	Plug Assembly				Stop	
Start Date:	3/3/2011	Start Qty:	80.00		Cust Item ID:	
Required Date:	3/7/2011	Req'd Qty:	80.00		Customer:	
Reference:						


Approvals:	Process Plan:	<u>W</u>	Date:	Tooling:		Date:		Run	Start	
	QC:		Date:	SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3492	Rev C								

100  
 Hardinge CNC LATHE SMALL 0.00  
 Hardinge Memo 0.00  
 Hardinge CNC Lathe Small 1-Turn as per Folio FA632 & Dwg D3492 □ Dwg Rev: C □ Folio  
 Rev: C


80  $\phi$

SA 11/3/7

110  
 QC2- Inspect parts off machine FAI/FAIB 0.00  
 QC Memo 0.00  
 Quality Control

80  $\phi$

SA 11/3/7

120  
 QC8- Inspect parts - second check 0.00  
 QC Memo 0.00  
 Quality Control

80  $\phi$

SA 11/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 66931

Thursday, March 03, 2011 8:02:17 AM



Page 2

Item ID:	D3492-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Plug Assembly					
Start Date:	3/3/2011	Start Qty:	80.00		Cust Item ID:	
Required Date:	3/7/2011	Req'd Qty:	80.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00				80		BR 11-3-8.	
140  Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powder Coating	Memo (Flat End Only) <input type="checkbox"/> START TIME: 11:40 <input type="checkbox"/> OVEN TEMPERATURE: 320° <input type="checkbox"/> FINISH TIME: 12:10	0.00				80		BR 11-3-8.	
150  QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00				80		M 11/03/08	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66931**

Thursday, March 03, 2011 8:02:17 AM



Page 3

Item ID: D3492-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug Assembly

Start Date: 3/3/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



Packaging

Identify as per dwg & Stock Location: FR-B

0.00

Memo

0.00

80BK11-3-8

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/9 MFMF11-03-08

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, March 03, 2011 8:02:14 AM

Page 1

Work Order ID: 66931



Parent Item: D3492-043



Parent Item Name: Plug Assembly

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP Rev: A 06.03.21 New Issue JLM  
IPP Rev: B 06-08-28 As per Rev B JLM  
IPP Rev: C 07-12-06 Rev C dwg DD verified by: EC  
IPP Rev: D 08-05-07 add note to count qty DD verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750 		Purchased	No			100	f	46.1898	0.0625	5.263158			
6061-T6 Round Bar .750"												SA 11/3/7	

Location

Loc Qty

Loc Code

MAT

46.173

115469

0.0027

115869

2.4453

116406

43.725

MAT012

0.016842105

112442

0.01684211

4.584

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

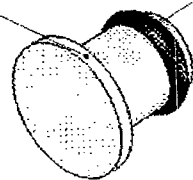
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3492-XX PLUG  
(SEE TABLE)

NAS1611 PLUG  
(SEE TABLE)



w/o 66931

### D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X	X						D3492-041	PLUG ASSEMBLY
		X					D3492-043	PLUG ASSEMBLY
			X				D3492-045	PLUG ASSEMBLY
				X			D3492-047	PLUG ASSEMBLY
					X		D3492-049	PLUG ASSEMBLY
						X	D3492-051	PLUG ASSEMBLY
							D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
							NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ △ △

#### NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

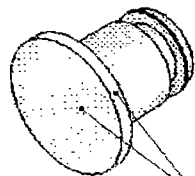
~~UNDER REVIEW~~

02.04.2005  
AK-ASS 08.11.12

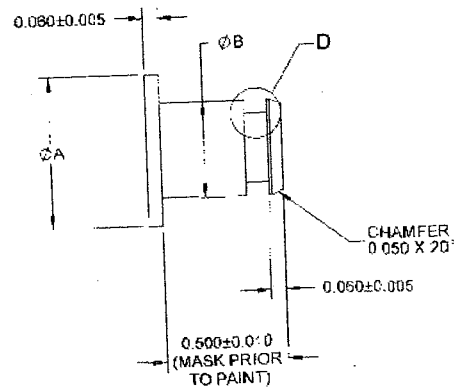
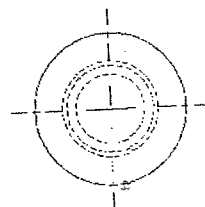
DEO ATTACHED

RELEASED  
02.10.10

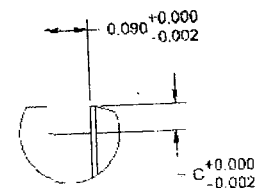
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PI	07.10.05
B	ADD -047, UPDATE D.M.A FOR -045	PI	06.05.11
A	NEW ISSUE	PI	08.01.04
RCV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO	REV. C
CHECKED		D3492	SHEET 1 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		PLUG	2:1
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD	
DATE	07.10.05	THIS DOCUMENT IS ISSUED AS A WORKING DRAWING AND IS NOT TO BE USED FOR CONSTRUCTION OR REPRODUCTION WITHOUT THE EXPRESS WRITTEN PERMISSION OF DART AEROSPACE LTD.	



POWDER COAT THESE  
FACES ONLY PER NOTE 2



**D3492-XX PLUG**



**DETAIL D**

*u/o 66931*

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	ME061T6R0.625
D3492-3	0.750	0.582	0.045	ME061T6R0.750
D3492-5	0.375	0.188	0.045	ME061T6R0.375
D3492-7	0.500	0.270	0.045	ME061T6R0.500
D3492-9	0.938	0.750	0.045	ME061T6R1.000
D3492-11	0.850	0.664	0.045	ME061T6R0.875
D3492-13	0.750	0.520	0.045	ME061T6R0.750

**NOTES:**

- MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.035 TO 0.010 MAX
- IDENTIFICATION: N/A
- WEIGHT: N/A

**UNDER REVIEW**

*03.04.12*  
*07.11.12*  
*ASSOS 11.12*

**DEO ATTACHED**

**RELEASED**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3492	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	4:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD	

DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR. <i>EL</i>	APPROVED <i>MP</i>	DE APPR. <i>MP</i>			
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05	DATE 08/11/05			

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

*w/o 66931*

WAS:

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

**RELEASED**  
08/11/10 *MP*

